

Date: Wednesday, 3/8/2006 10:38:16 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: DUCT
Job Number	: 26117		
Estimate Number	: 12315		
P.O. Number	: N/A	Part Number	: D34731
This Issue	: 3/8/2006 S.O. No. : N/A	Drawing Number	: D3473 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : PURCHASED PARTS	Drawing Revision	: A
Previous Run	: N/A	Material	: N/A
Written By	: <u>See Comment Below</u>	Due Date	: 3/31/2006
Checked & Approved By	: <u>06-03-08</u>	Qty:	10 Um: Each
Comment	: Est Rev:A New Issue 06-03-02 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: Issue P/O: 00000768 06/03/09
E-mail or Ship DXF file to vendor
Laser cut flat pattern as per Dwg D3473
Possible supplier: Ind. Laser
Material release note is required.

2.0	D34731F	DUCT FLAT PATTERN
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Comment: Qty.: 1.0000 sf(s)/Unit Total : 6.0000 sf(s)
FLANGE PLATE

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
Receive & Inspect For Transit Damage
Ensure material certification is attached

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr if necessary.

2-Roll as per Dwg D3473

SRB 06/04/09 9

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		One taken for template	JB	06/03/29	1	JB	JB

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/04/26

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/04/24	5	2 piece were Scrap out of Tolerance	JB	Scrap + destroy	JB	JB	JB	JB

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DUCT

Job Number: 26117

Part Number: D34731

Job Number:



Seq. #:

Machine Or Operation:

Description :

3-Form Small Flange as per Dwg D3473 using DT8861 Base & Dt8847B Male Die

4-Form Large Flange as per Dwg D3473 Using DT8862

5-Spot Weld as per Dwg 3473

6.0

QC5/

WELD INSPECTION



Comment: WELD INSPECTION

SB 06/04/24 ⑦

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

AB 06/04/25 ⑦

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DP 06/04/26 ⑦

Job Completion



LN 06/04/26

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

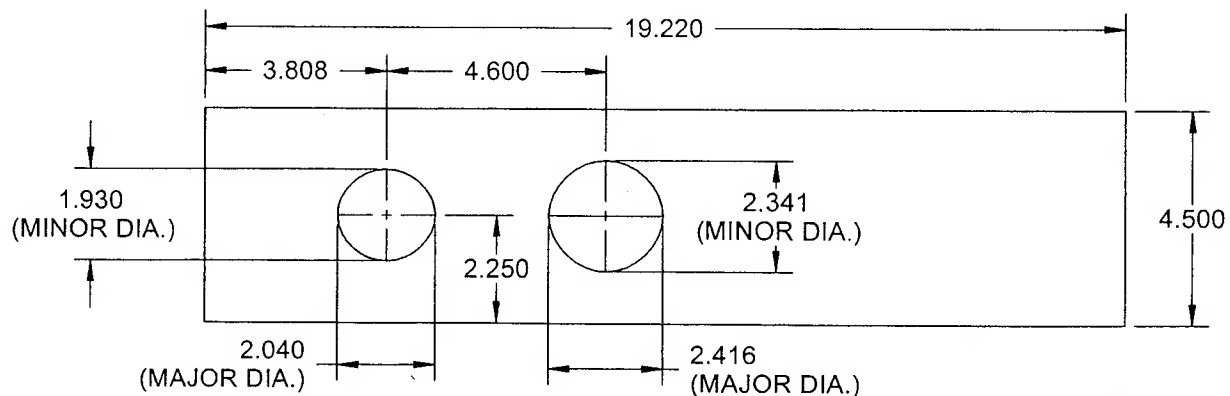
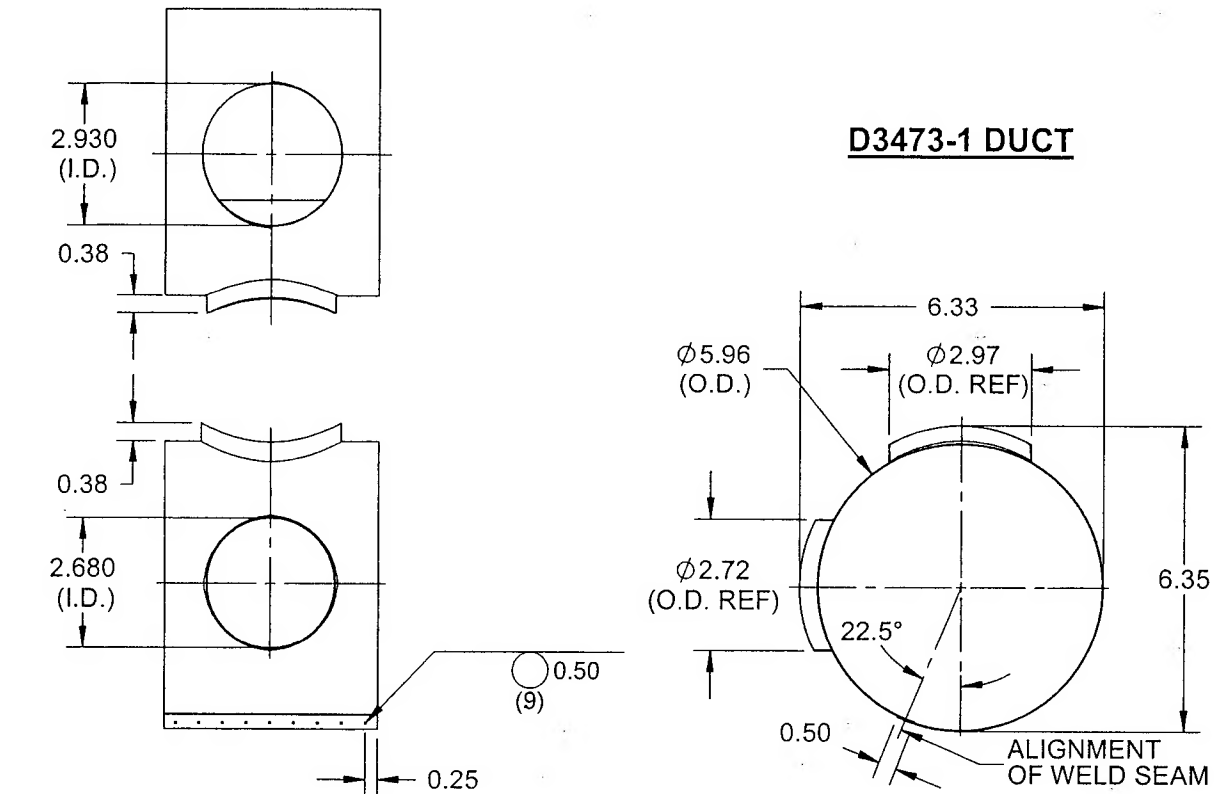
QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

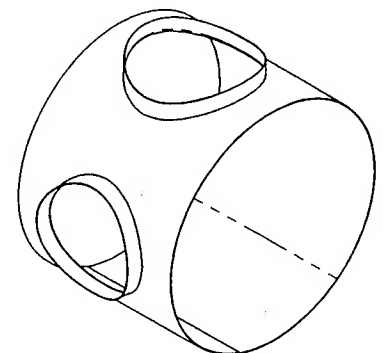
PRELIMINARY ISSUE

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3473	REV. A SHEET 3 OF 7
DATE 06.02.07	TITLE BLOWER INLET ADAPTER		SCALE 1:4



NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED)
2B FINISH 26 GAUGE SS (0.018 THICK)
- 2) SPOT WELD PER DART QSI 004
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010



MATERIAL TEST REPORT

From: NORTH AMERICAN STAINLESS CANADA, IN
740 IMPERIAL ROAD NORTH

Page : 1
Heat/Lot : 86K8
TIN : B42748

Sold To: INTEGRIS METALS, LTD.
7910 40TH STREET SE
CALGARY, AB T2C2Y3

Ship To: ***CUSTOMER PICKUP***
4375 14TH STREET NORTHEAST
CALGARY
ABT3E7A9

Vendor Information

Cust PO #: 406824

Cust PO DT: 11/03/05

Specifications

STAINLESS STEEL SHEET, COLD ROLLED, ANNEALED AND PICKLED.
ASTMA240/04a 480/04a, 666/03, ASMESA240/04-A05, 480/04-A05, SA666/04
Q08766D-A X 1/8 PRM, AMS5513H X MRK&FIN, MIL5059D, AMD3, X CRWN MEAS
CORROSION: ASTM A262/02aB; 180Bend-OK
Buyer Part: 4288441
304 2B .1305 IN 48 IN 96 IN
Country of Origin: UNITED STATES

Mechanical Tests

		UOM	L	O		UOM	L	O
Yield Strength - 0.2% Offset	40	KSI	F	TRANSV				
Tensile Strength (UTS)	93.3	KSI	F	TRANSV				
Rockwell B	85		F	TRANSV				
Pct Uniform Elong 2 In/50mm	57.01	PCT	F	TRANSV				
Rockwell A	85		T	TRANSV				

Chemical Composition

C Carbon-Fct	.059	CR Chromium-Pct	18.360
CU Copper-Fct	.342	MN Manganese-Pct	1.643
MO Molybdenum-Pct	.285	N Nitrogen-Pct	.037
NI Nickel-Fct	8.150	P Phosphorus-Pct	.029
SI Silicon-Fct	.289		

Comments

MATERIAL TEST REPORT

From: NORTH AMERICAN STAINLESS CANADA, IN
740 IMPERIAL ROAD NORTH

Page : 2
Heat/Lot : 86K8
TIN : B42748

Material free from mercury contamination. No weld repairs.
EN 10204 3.1 PED 97/23/EC Annex1, Para. 4.3 Q08763F Cond A
This document certifies the material has been tested in
accordance with applicable specifications described herein
and has met those requirements.

QA by ERIC HESS 02/01/2006

Miscellaneous Data

GUELPH, ONT. K123
Control #: S/C60214
Part #: 74271441
.135 X .48 X .96

Date: 03/17/06

SOLD TO: INDA. LAFER

TO 110880

S/O 90-374786 - 02

[Signature] 3/17/06

The Chemical Analysis and Mechanical Test
data was received via EDI from the above
mentioned vendor.

INTEGRIS METALS, LTD.

